



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Ship May 9

C2-3-11

Job Sheet 175622



Part No: C2-3-11

Job Qty: 10 pcs

Part Name: Actuator



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/9/18

Job Tracking No:

Due Date: 4/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C2-3-11 Rev 15 IPP Rev A 18.04.06 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		4/27/18	0.00	0.00	Start Up Machining-4		
120	Mori Seiki	10 pcs		4/28/18	0.00	10.00	MORI SL-154		
130	QC	10 pcs		4/28/18	0.00	0.00	QC2 Machining-5		
140	CNC Vertical Machining	10 pcs		4/30/18	1.50	5.00	MORI NV5000 1 HAAS		
150	QC	10 pcs		4/30/18	0.00	0.00	QC2 Machining-5		
160	QC	10 pcs		4/30/18	0.00	0.00	QC8 Machining-5		
170	Packaging	10 pcs		4/30/18	0.00	0.00	Packaging3-2		
180	QC	10 pcs		4/30/18	0.00	0.00	QC21		

Part Op 120 - 1-Machine as per folio FC 017 FOLIO REV: DWG REV: 9-89 2-Debur
Descriptions: 140 - 1-Machine as per folio FC 017 FOLIO REV: DWG REV: 9-89 2-Debur

"Generate serial # and see PEC for Programming"

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4 H900-R1.375	17-4 SS H900 Round Bar 1.375"	1.5000 ft (.15 ea)	90-Start up Operation	

M17-4 H1150 R1.500

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4 H900-R1.375	2	10	0
	M17-4 H1150-R1.500		=8	

Part Specifications

Specifications could not be found



Container No: S075123



Part: C2-3-11

Job No: 175622

Serial No/Batch: S075123

Revision: 15

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

1/18 2:25 PM Dart.lajeunesse.marie

Date: 05/28/18

577

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

DART AEROSPACE LTD		Work Order:	175622
Description: actuator		Part Number:	C2-3-11
Inspection Dwg: C2-3-11	Rev: 15	Page 1 of 2	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.597	$\pm .005$	.592			Mic LPO9	
.27	$\pm .01$	.271			Vern LPO9	
R.05	$\pm .01$	.05			↓	
.465	$\pm .005$	.463			H.G	
Ø.1285	$\pm .005 / -.000$	.129			Gage Pin	
.244	$\pm .005$	.2425			H.G	
Ø.375	$\pm .005$	.375			gage pin	
.65	$\pm .01$	.660			Vern LPO9	
Ø.562	$\pm .000 / -.002$	.561			Mic LPO1	
.02 x 45°	$\pm .01 \times .5^\circ$	.02 x 45°			Vern LPO9	
.617	$\pm .000 / -.003$	.617			Mic LPO1	
.651	$\pm .005$	.653			H.G	
Ø.696	$\pm .005$	.695			Mic LPO1	
.02 x 45°	$\pm .01 \times .5^\circ$	.025 x 45°			Vern LPO9	
Ø.562	$\pm .000 / -.002$	.561			Mic LPO1	
Ø.308	$\pm .000 / -.002$	.307			Mic LPO1	
.02 x 45°	$\pm .01 \times .5^\circ$	.022 x 45°			Vern LPO9	
Ø.199	$\pm .005$	.199			Gage Pin	
.09	$\pm .01$	.090			Vern LPO9	
R.02	$\pm .01$	.02			↓	
.01 x 45°	$\pm .01 \times .5^\circ$	.01 x 45°			↓	
1.596	$\pm .005$	1.595			↓	
.923	$\pm .005$	.922			H.G	
.748	$\pm .005$	.747			↓	
.470	$\pm .005$	.470			↓	
.136	$\pm .005$	.136			↓	
.345	$\pm .005$	.345			Vern LPO9	
.188	$\pm .005$	.189				
.328	$\pm .005$	.326				

Measured by: <i>[Signature]</i>	Checked by:	QC Inspector:
Date: 15-05-27	Date:	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



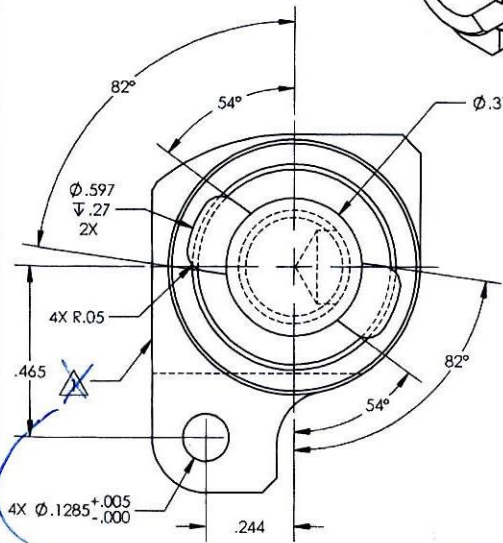
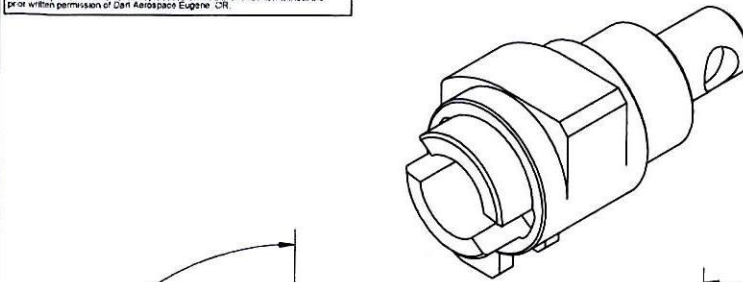
QA Closed: _____ Date: _____

Work Order update only ☐

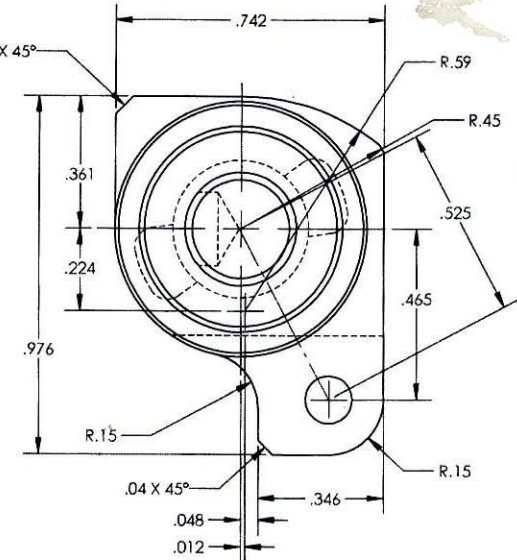
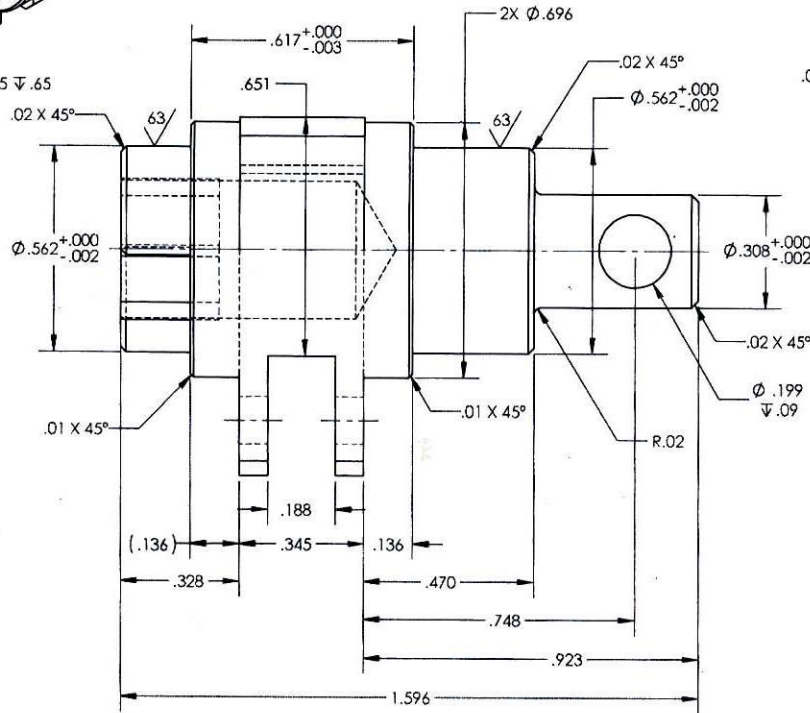
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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

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REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
13		CHANGED TOLERANCE ON $\phi .1285$ HOLE FROM $\pm .003$ TO $\pm .005$ / $-.000$.	8/27/2012	JAG	
14	14-0104	CH'D TITLE BLOCK WAS PER BARN & DART. ADDED MACHINE ENGRAVE NOTE. CH'D DIMENSION TOLERANCES ON NON-CRITICAL DIMENSIONS.	8/6/2014	DPD	RW
15	17-0062	UPDATED TO NEW STANDARDS. CH'D MATL WAS SS 17-4PH B SS 17-4PH H1025-H1150. REMOVED	3/17/2017	SM	JAG



ACCEPTABLE TO OMT
SIN MRL



NOTE:
MACHINE ENGRAVE BATCH NUMBER.

DART AEROSPACE	
TITLE ACTUATOR	
DWG NO. C2-3-11	REV. 15
MATERIAL: SS 17-4PH H1025-H1150	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
FINISH: .XXX $\pm .005$ FRACTIONS $\pm 1/8$	
PRECISION: .XX $\pm .01$ ANGLES $\pm 5^\circ$	
SURFACES: .X $\pm .1$ SURFACES $\pm 125^\circ$	
SPEC:	
1. BREAK ALL SHARP EDGES	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL	
DRAWN BY: CANAM	
CHECKED: DD 03/17/2017	
DATE APPR: AA 08/15/2017	
DATE APPR: JL 08/28/2017	
APPROVED: JAG 07/08/2017	
SCALE: 3:1	DATE: 11/12/2001
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/C	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			C2-3-11	1	ACTUATOR	SS 17-4PH H1025-H1150	

DQA: _____ Date: _____



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Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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